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<p>(54) Title: MOISTURE VAPOR PERMEABLE MATERIALS CONTAINING SEGMENTED BLOCK MULTIPOLYMER</p> <p style="text-align: center;">MATERIAL A WITH 0.5% OF COPOLYMER I</p> <table border="1"> <caption>Data points from Graph</caption> <thead> <tr> <th>$1/T (\text{MIL}^{-1})$</th> <th>MVTR ($\text{g/m}^2/24 \text{ HR}$)</th> </tr> </thead> <tbody> <tr> <td>0.5</td> <td>1000</td> </tr> <tr> <td>1.0</td> <td>2000</td> </tr> <tr> <td>2.0</td> <td>4500</td> </tr> </tbody> </table> <p>(57) Abstract</p> <p>Polymeric materials characterized by hard segments and copolymer soft blocks comprising hydrophobic and hydrophilic components. The polymeric materials may be mixed with a base polymer and/or inorganic salts. The polymeric materials and mixtures containing same are characterized by improved moisture vapor transmission rates. The polymeric materials may be formed into films for use as wound dressings, burn dressings, surgical drapes, semipermeable membranes, and coatings for textiles.</p>				$1/T (\text{MIL}^{-1})$	MVTR ($\text{g/m}^2/24 \text{ HR}$)	0.5	1000	1.0	2000	2.0	4500
$1/T (\text{MIL}^{-1})$	MVTR ($\text{g/m}^2/24 \text{ HR}$)										
0.5	1000										
1.0	2000										
2.0	4500										

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MOISTURE VAPOR PERMEABLE MATERIALS CONTAINING SEGMENTED
BLOCK MULTIPOLYMER

The present invention is directed to moisture vapor permeable materials. These materials are segmented block multipolymers and may be used alone or in a mixture with 5 a base polymer. Such materials are useful as membranes, wound dressings, surgical drapes and burn dressings and as coatings for fabrics for apparel and industrial uses.

Moisture vapor permeable backing materials having a moisture vapor permeable pressure sensitive adhesive are 10 disclosed by Hodgson in Patent No. 3,645,835. The backing materials disclosed therein are synthetic polymers which are continuous and nonpermeable to liquid water. The adhesive materials are also permeable to moisture vapor. There is no disclosure of a discrete 15 segmented block copolymer additive to either the backing material polymer or the adhesive material polymer to increase the moisture vapor transmission capability.

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Other materials have been suggested for use as additives to polymers used in bio-medical devices, however, not for the purpose of enhancing moisture vapor transmission.

For example, Nyilas in Patent No. 3,562,352 suggests

- 5 cross-linked thermosetting polysiloxane-polyurethane block copolymers for use as blood contact surfaces of bio-medical devices. The technique disclosed therein includes fabricating the entire bloodcontacting device from such block copolymers or coating such devices with
10 the copolymers.

Minor amounts of block copolymers including segments of polydimethylsiloxane and blocks of polycarbonate, polystyrene, poly-(2,6-diphenyl-1,4-phenyleneoxide), and polyamide-imide have been blended with base homopolymers

- 15 for modifying the surface properties of the homopolymers. Gaines, et al. in Patent No. 3,961,122 suggest using such surface modified polymers as thin films while Gaines, et al. in Patent No. 3,686,355 suggest a variety of uses, including bulk uses.

- 20 Flexible, soil resistant sheet material comprising a fibrous mat covered with a polyurethane composition is disclosed in Patent No. 4,233,359. The polyurethane composition contains 0.1 to 5% of a surface active agent comprising a polyethylene oxide hydrophilic component and

- 25 a hydrophobic component selected from polyalkylene oxides (except polyethylene oxides), aliphatic polyesters and mixtures thereof. No hydrophobic soft blocks such as polydialkylsiloxanes, are disclosed as part of the surface active agent.

- 30 Block copolymers useful in the treatment of fibrous materials to improve soil release properties are disclosed in Patent No. 3,565,845. The block copolymers are not mixed with a base polymer when used to treat the fibrous materials.

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When applying dressing materials to wounds on the body, it is desired to utilize a material which is not permeable to liquid water in order to keep the wound from external contact with liquids, dirt and other particles.

5 Additionally, the liquid water impermeability is desirable in order to minimize or eliminate transepidermal water loss from the body through the wound. On the other hand, to facilitate healing and to avoid maceration of the skin surrounding the wound it is necessary that
10 moisture formed at the wound site be removed to a great extent. Therefore, this moisture may be removed by moisture vapor transmission through the wound dressing.

It is thus desirable to have a material as a wound dressing which is both impermeable to liquid water but
15 yet highly permeable to water vapor, while still retaining structural integrity sufficient for the wound dressing, such as having high tear strength, flexibility, elongation (so that the material may be stretched over joints and limbs to conform to contours of the body) and
20 high tear propagation so that cuts intentionally created in the material do not propagate across the dressing and cause failure.

In the textile industry, synthetic materials have been used to impart soil-releasing properties and water-proofing to fabrics. However, such materials suffer from the disadvantage of poor moisture vapor transmission. Thus perspiration tends to condense inside clothing made of such fabrics, making them uncomfortable particularly in
25 hot or humid weather.

30 It would thus be desirable to provide textile materials which, in addition to having excellent tensile strength, elongation and impermeability to liquid water, also have a high permeability to water vapor.

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It is therefore an object of the present invention to provide a wound dressing material having high moisture vapor transmission but being impermeable to liquid water.

5 It is a further object of the present invention to provide a segmented block copolymer additive compatible with numerous base polymers to form wound dressings, burn dressings, and surgical drapes having high moisture vapor transmission capability.

10 It is another object of the present invention to provide a segmented block copolymer which may be used alone or in a mixture with a base polymer to form coatings for textiles having high soil-release properties, high impermeability to liquid water, high textile strength and elongation, and high permeability to water vapor.

15 It is also an object of the present invention to provide a method for controlling the moisture vapor transmission properties of numerous base polymers by using segmented block copolymer additives.

These and other objects will become apparent from the
20 following description of the preferred embodiments.

The present invention is directed to moisture vapor permeable materials comprising segmented block multipolymer which may be used alone or in a mixture with a base polymer. The block multipolymer comprises an
25 essentially linear segmented copolymer chain characterized by at least one hard segment and at least one copolymer soft block comprising hydrophobic and hydrophilic components. The moisture vapor transmission materials according to the present invention are useful
30 as burn dressings, wound dressings, surgical drapes, surgical sutures, and the like, and as coatings for apparel and industrial uses.

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In the accompanying drawings:

FIG. 1 is a plot of moisture vapor transmission rate vs. film thickness of Material A described in Example 1.

FIG. 2 is a plot of moisture vapor transmission rate vs.

5 reciprocal film thickness of Material A described in Example 1.

FIG. 3 is a plot of moisture vapor transmission rate vs. reciprocal film thickness of Material A containing 0.5% by weight of siloxane copolymer additive I described in

10 Example 1.

FIG. 4 is a plot of moisture vapor transmission rate vs. reciprocal film thickness of Material A containing 0.5% of siloxane copolymer additive II described in Example 1.

FIG. 5 is a plot of moisture vapor transmission rate vs.

15 reciprocal film thickness of Material A containing 0.5% by weight LiBr.

FIG. 6 is a plot of moisture vapor transmission rate vs. reciprocal film thickness of Material A containing 0.5% by weight siloxane copolymer I and 0.5% LiBr.

20 The materials according to the present invention will usually be formed by admixing a base polymer and a segmented block multipolymer additive in a solution and casting the admixture as a film. Removing the solvent by evaporative procedures will result in a material having a
25 high moisture vapor capability.

When used without a base polymer, the block multipolymer will usually be dissolved in a solvent, then cast as a film or coating. This method is particularly preferred for forming moisture vapor permeable coatings on tex-

30 tiles.

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As used herein, the term "base polymer" will refer to the polymer whose moisture vapor transmission characteristics are modified by the block multipolymer additive. Such base polymers may be segmented or block copolymers, 5 blends thereof, thermoplastic homopolymers, or homopolymer mixtures which may also contain plasticizing agents. For example, plasticized polyvinylchloride and polyethylene may be used as base polymers.

Typical base polymers which may be utilized according to 10 the present invention include polyurethanes, polysulfones, polyesters, polyethylenes, polypropylenes, polystyrenes, poly(acrylonitrile-butadiene-styrene), polybutadiene, polyisoprene, styrene-butadiene-styrene block copolymers, styrene-isoprene-styrene block copolymers, 15 poly-(4-methylpentene), polyisobutylene, polymethylmethacrylate, polyvinylacetate, polyacrylonitrile, polyvinylchloride, polyethylene terephthalate, cellulose and its esters or derivatives, and the like.

The term "segmented" refers to the relatively short 20 length of repeating units, e.g., less than about ten monomeric units, but preferably less than three monomeric units, typically alternating more than once, with structural formulas, such as ABAB.

A preferred class of base polymers includes the polyurethanes, including polyether urethane ureas, polyether urethanes and polyester urethanes. The polyurethanes or polyurethane ureas may be the reaction products of 25 polymeric ether glycols and a diisocyanate, and a chain extending diamine or dihydroxy derivative. By the use of various types of isocyanates (e.g., aliphatic or aromatic), 30 glycols (e.g., polyethylene, polypropylene, or polytetramethylene oxides), and chain extenders (aliphatic or aromatic), the structural properties of the base polymer may be varied depending upon the end use of 35 the material.

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A particularly preferred base polymer is a polyurethane urea formed from the polymerization of diphenylmethane diisocyanate (MDI), ethylene diamine (ED), and polytetramethylene oxide (PTMO).

- 5 Other base polymers include polyester-polyethers, polyesters (e.g., Dacron), polyether-polyamides, polyamides (e.g., nylon), styrene-isoprenes, styrene butadienes, thermoplastic polyolefins, styrene-saturated olefins, copolyesters, ethylene vinyl acetate, ethylene ethyl
10 acrylate, ionomers, thermoplastic polydienes, and the like.

- The segmented block multipolymers according to the present invention comprise an essentially linear segmented copolymer chain characterized by at least one hard
15 segment and at least one copolymer soft block comprising hydrophobic and hydrophilic components. The block multipolymer may or may not be of the thermosetting type. The hard segment may be relatively short in length, typically including from one to ten repeating units.
20 Preferably, the hard block will be a homopolymer wherein the hard segments comprise urethane selected from the same polymers which comprise the preferred polyurethane urea base polymers. When the segmented block multipolymer is used as an additive the similarity of the urethane
25 segments of the additive and the urethane of the base polymer will cause the additive to be at least partially compatible with the base polymer in the admixture.

- The copolymer soft block(s) of the block multipolymer may comprise both hydrophobic and hydrophilic components.
30 The hydrophobic components of the soft block may be, for example, a tetraalkylene oxide or a polydialkylsiloxane. Techniques for forming siloxane copolymers are known, e.g., as described by Noll, Chemistry and Technology of Silicones (Academic Press, 1968), disclosure of which is
35 incorporated by reference herein. Other suitable

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hydrophobic soft block components include polyfluoroalkyl alkylsiloxanes, polyfluoroalkyl acrylates and methacrylates and copolymers thereof, polyolefins, polydienes, polyfluorocarbons, and the like.

5. The hydrophilic component of the soft block may be a polyalkylene oxide, polyvinylalkanoate (such as, polyvinyl acetate, polyvinylpropionate), and the like.

A preferred first class of compositions is one in which the soft blocks consist of both hydrophilic and hydrophobic components. The preferred hydrophilic component is polyethylene oxide (PEO) and the preferred hydrophobic component is polytetramethylene oxide (PTMO). The hard segments preferably comprise condensation products of diphenylmethane diisocyanate (MDI) with a diamine or diol. A particularly preferred hard segment will contain hard segments of MDI and ethylene diamine.

A preferred second class of compositions is one in which the soft blocks comprise hydrophilic and hydrophobic components, preferably the PEO and PTMO components described above, and another hydrophobic component, preferably a polydialkylsiloxane. The hard segments will be as described above, i.e., copolymers of MDI with a diamine or diol.

A particularly preferred composition of the first class will comprise the following:

	15-50%	(by weight) hard segment
	20-45%	Polyethylene oxide (1000-3000 mol. wt. (number avg.))
	25-65%	Polytetramethylene oxide
30	0-2%	antiblocking/wetting agent, preferably a siloxane
	100%	

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A particularly preferred composition of the second class comprises urethane hard segments (formed from MDI and butanediol) and soft blocks of siloxane (hydrophobic), polyethylene oxide (hydrophilic) and polytetramethylene oxide (hydrophobic).

In addition to the above block multipolymer, the moisture vapor permeable material according to the present invention may contain an inorganic salt, such as lithium bromide. Other inorganic salts may be used which are soluble in the casting solvent for the polyurethane urea.

It is preferable that both the organic polymer and the inorganic salt be used in combination, since in many cases, the moisture vapor transmission rate of the base polymer will be enhanced by an unexpected amount.

The amounts of each of the block multipolymer additives which will be added to the base polymer, when used, will depend upon the base polymer and additives which are used. Generally, the organic polymer additive will be added in an amount to achieve a silicone (or other hydrophobic soft block component) concentration of at least 0.5% (by weight) in the admixture containing both base polymer and additive. The silicone (or other hydrophobic soft block component) content may vary between 0.1% and 50%.

The inorganic salt additive, if used, will generally be added in an amount to achieve a final concentration of about 0.5% (by weight) of the salt in the admixture containing the base polymer and all of the additives. The concentration of the inorganic salt may vary between 0.01% and 1.0%.

In the above concentration ranges, the additives according to the present invention will cause an increase of the moisture vapor transmission rate of the base polymer by about 10 to 500%, when cast in films ranging in thickness from 0.5 mil to 2.0 mil (1 mil = 1/1000 inches = 25.4001 microns).

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To cast the films, the base polymer will normally be dissolved in an appropriate solvent, such as dimethylacetamide (DMAC), dimethylformamide (DMF), toluene/isopropanol, tetrahydrofuran (THF), and the like. The 5 additives will then be added and the film will be cast according to conventional procedures onto a support. Upon evaporation of the solvent a film will remain comprising materials according to the present invention. Similar methods may also be utilized to form thermoplastic 10 films.

The base polymers utilized according to the present invention may be those conventionally known in the art, i.e. polyurethanes, polyetherurethaneureas, polyether-urethanes, polyesterurethanes, polyester/polyether, 15 thermoplastic elastomers, and the like, many of which are commercially available as Estanes (B.F. Goodrich Company), Pellethane (Upjohn), Hytrel and Lycra Spandex (DuPont).

20 The segmented block multipolymers according to the present invention may be suitably formed of block copolymers of alternating hard segment and soft block components interlinked by chemical bond in accordance with the method set forth by Noshay and McGrath, Block Copolymers Overview and Critical Survey (Academic Press 25 1977), the disclosure of which is incorporated by reference herein. A suitable number of repeating units of each polymer of the hydrophobic and hydrophilic soft block components will typically be on the order of 1 to 100 units.

30 The procedure for preparation of the segmented block multipolymer additive may be performed by several procedures which differ in the degree to which the structure of the resultant product may be defined.

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One procedure involves a coupling of two (or more) preformed blocks or segments which are prepared in separate reactions prior to the coupling reaction. This procedure involves a well defined structure if the 5 coupling reaction precludes like blocks or segments from reacting with themselves, but only allows dissimilar blocks or segments to couple to one another.

Other coupling reactions may occur resulting in a less defined structure if the two preformed blocks or segments 10 possess the ability (via the coupling reaction) to react with themselves as well as the dissimilar block or segment.

Additional coupling reactions may occur when a single (or more) preformed block or segment is coupled with a second 15 block or segment created during the coupling reaction. In this case the initial length of the preformed block or segment is known, by virtue of their separate reaction used to prepare but the sequence of the distribution of the copolymer is not known exactly since both coupling 20 and chain growth is possible in the reaction. Suitable methods of forming these and other such copolymers for use in the present invention are set forth in the afore-mentioned Noshay and McGrath publication.

A typical procedure is given below:

25 Charge the reactor with 9.75 g (0.015 moles) of a linear, difunctional, hydroxy terminated polytetramethylene oxide, 72 g (0.03 moles) of a linear, difunctional, hydroxy terminated polyethylene oxide/polydimethyl-siloxane block copolymer, and 400 ml of a 1:1 (V/V) mixture 30 of dimethylsulfoxide and methyl, isobutyl, ketone. Heat the mixture to 75-80°C and add 37.5g (0.15 moles) diphenylmethane diisocyanate (MDI) dissolved in 100 ml of a 1:1 (V/V) dimethylsulfoxide methyl, isobutyl ketone solvent mixture. Maintain the 75-80°C temperature with

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- agitation and a dry nitrogen purge for three hours. Cool the reaction mixture to 45°C, then add 9.5 g (0.106 mole) butanediol in 200 ml of the 1:1 (V/V) dimethylsulfoxide/methyl, isobutyl ketone solvent. Maintain the 45°C
5 temperature for approximately 2 hours. Isolate the polymer via coagulation in water.

The above preferred additive will be used in the preferred base polymer, which is a low durometer polyurethaneurea based on diphenylmethane diisocyanate (MDI),
10 ethylenediamine (ED) and polytetramethylene oxide (PTMO). A typical procedure is outlined below.

Charge a stirred, dry nitrogen purged reaction vessel with 8.60 g (0.034 moles) diphenylmethane diisocyanate, 50.0 g (0.025 moles) polytetramethylene oxide, and 100 ml
15 anhydrous dimethylformamide at 45°C. Maintain the 45°C temperature for 1 hour, 15 minutes. Remove the heat, dilute the mixture with 200 additional ml anhydrous dimethylformamide, and add 0.54 g (0.009 moles) ethylene diamine incrementally over a 20 minute period.

20 Typically, the base polymer will be dissolved in the solvent, preferably dimethylacetamide, and the additives will be added to the solution based on the weight of the base polymer. The amount of solvent which is used will depend at least in part on the thickness of the desired
25 film. The thicknesses of the films which are desired will depend upon the ultimate use to which the film will be utilized.

The compatibility between the base polymer and the organic polymer additive may be controlled by using a
30 constant silicone soft segment and varying the chemistry of the remainder of the components of the admixture. Therefore, if the base polymer is Estane 5714, the additive may be a polymer containing a low molecular weight silicone with the remainder of the additive

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comprising MDI, butanediol, and PTMO. On the other hand, using the same silicone content in a copolymer or a polymer additive containing ethylene diamine, polybutylene adipate and MDI may give a different compatibility 5 with the same Estane 5714 base polymer at equivalent concentrations. Therefore, the choice of the amounts and types of additives and base polymers which are utilized according to their present invention may be readily determined to achieve the most effective MVTR according 10 to the teachings of the present invention.

In addition to the organic multipolymer additive and, if used, the inorganic salt additive, other additives may be utilized in the admixture depending upon the intended use of the film. For instance, if the films are to be 15 utilized as burn wound dressings, it may be desirable to incorporate a water soluble leachable material. In this manner the higher the content of water soluble components, the higher the MVTR following dissolution of the leachable by the water produced by the wound. Furthermore, 20 the water soluble leachable may be a carrier for an antimicrobial agent which will also serve to prevent or retard infection in the wound. Therefore, dissolution by the water in the wound and/or softening and flowing due to body heat will distribute the antimicrobial agent over 25 the wound in a controlled release fashion. The antimicrobial agent may be mechanically mixed with the water soluble leachable material prior to addition to the film casting solution or may be chemically bonded to the water soluble leachable material.

30 Wound dressings according to the present invention may be made which have high elongation and excellent tear propagation so that the films may be stretched over joints and limbs to conform to parts of the body, while retaining the capability of being intentionally torn or 35 cut without propagating rips across the dressing. A particularly preferable wound dressing material may

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comprise a polyether/polyester elastomer commercially available under the name Hytrel (Dupont) as the base polymer. Particularly preferred wound dressings may be formed utilizing a silicone containing block copolymer 5 additive according to the present invention together with polyethyleneglycol, which is a water leachable component. For example, Hytrel 40D may be dissolved in methylene chloride with a thixotropic additive, such as Cab-O-Sil fume silica, to thicken the solution. Polyethyleneglycol 10 may be added, which also increases the polarity of the system. This, in turn, increases the effectiveness of Cab-O-Sil as a thixotropic agent.

Textiles formed according to the present invention will have low permeability to liquid water, high permeability 15 to water vapor, high tensile strength and elongation. Generally, fabrics will be coated with a composition comprising either a segmented block multipolymer or a mixture of a base polymer and block multipolymer additive by conventional coating techniques. The compositions 20 according to the present invention are particularly advantageous as fabric coatings due to excellent adhesive properties, and lack of tackiness which allows the coated fabrics to be easily sewn. In addition, the viscosity of the bulk composition is in the range which permits easy 25 handling for coating techniques. Finally, the coated fabrics have a pleasing texture and are more cloth-like in feel than conventional water impermeable synthetic materials which characteristically have boardy texture. While not intending to limit the invention by a 30 particular theory, it is believed that commercially available water impermeable coated textiles are micro-porous while the coated textiles according to the present invention form a substantially solid sheet of water-vapor permeable material to give a pleasing cloth-like texture 35 while improving the soil-release and liquid water impermeability. Coated fabrics according to the present invention are useful as rainwear, upholstery, shoe tops,

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tablecloths, tarpaulines, protective interliners for clothing proofed against chemical agents, and similar uses where liquid, e.g., water impermeability and water vapor permeability is desired.

- 5 Having described the preferred embodiments, the following examples are presented, but the invention is not intended to be limited thereto.

Example 1

10 HIGH MOISTURE VAPOR TRANSMISSION RATE POLYMER
USING POLYURETHANEUREA AS THE BASE POLYMER

Materials

15 Five solutions of A, a low durometer polyurethaneurea based on diphenylmethane diisocyanate (MDI), ethylene diamine (ED) and polytetramethylene oxide (PTMO) were prepared in dimethylacetamide (DMAC). Modifying agents were added to the urethane solution based on the weight of the urethane polymer, resulting in the following solutions:

- 20 a) A
b) A with 0.5% polysiloxane (I)
c) A with 0.5% polysiloxane (II)
d) A with 0.5 Lithium Bromide
e) A with 0.5 polysiloxane (I) and 0.5% lithium bromide

25 Copolymer (I) consists of a urethane hard block and silicone and polyethylene oxide soft blocks. Copolymer I contains 28% polysiloxane by weight which equates to adding 1.78% of the copolymer in A to yield a 0.5% polysiloxane concentration. Copolymer II consists of 30 urethane and siloxane blocks only. II contains 50% silicone which equates to adding 1.0% of the copolymer to A to yield a 0.5% by weight silicone concentration.

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Lithium bromide is a salt which increases the polarity and solvent strength of DMAC.

Films ranging in thickness from 0.5 mil to 2.0 mil in increments of 0.5 mil were cast from solution onto

- 5 release paper by the knife over roll technique. A Talboys web coater was used in the film casting procedure which was equipped with a four foot convection oven maintained at $75 \pm 5^{\circ}\text{C}$.

The fully cured cast films were removed from the release

- 10 paper. A micrometer accurate to ± 0.0005 inch was employed to measure the thickness of the films.

Fisher/Payne Permeability cups were used to determine the moisture vapor transmission rate (MVTR) of the test specimens. Ten milliliters of distilled water was

- 15 dispensed into the flanged cup. A disk of the sample was placed over the cup flange followed by a butyl rubber sealing gasket and a metal flat ring. The sample, gasket and ring were secured to the cup flange with three clamps with sufficient pressure to insure a tight seal.

- 20 The MVTR of the unsupported cast films were determined by the standard test conditions of ASTM E-96, procedure BW. This procedure involved testing the material at $23 \pm 1^{\circ}\text{C}$ and $50 \pm 2\%$ relative humidity. The cup was inverted allowing the distilled water to cover the inner surface
25 of the film. Air was continuously circulated over the face of the inverted cup at 500 ft/min.

The samples were conditioned for 24 hours at 23°C and 50% RH prior to testing. The MVTR of five specimens from each cast film were measured. The assembled cups were

- 30 placed in the test chambers for one hour. The temperature, air velocity and relative humidity were recorded. At the end of this time period, each cup was accurately weighed to 0.1 mg. The cups were inverted and returned

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to the test chamber for two hours and reweighed. The MVTR of each cup was calculated from equation (1).

$$\text{MVTR} = (g) (24 \text{ hr}) / (t) (A)$$

where:

- 5 g = weight change during test (grams)
 t = time of analysis (hour)
 A = test area (cup mouth area) (m^2)

Each film was analyzed on three separate days to determine the reproducibility of the coating and testing
 10 methods.

The means and standard deviation (N=5) of the MVTR of each solvent cast film are contained in Table 1.

Table 1. MVTR* OF UNSUPPORTED CAST FILM

	Sample/Thickness (nom)	<u>MVTR (g/m^2/24 hr.)</u>		
		Test 1 $\bar{x} \pm \sigma$	Test 2 $\bar{x} \pm \sigma$	Test 3 (N=5) $\bar{x} \pm \sigma$
Polyurethaneurea (A)				
	0.5 mil	3555±254	2964±217	3844±256
	1.0 mil	2282±198	1925±84	2348±321
20	1.5 mil	1535±94	1378±138	1303±59
	2.5 mil	1210±83	1355±312	1143±123
A w/0.5% Siloxane (I)				
	0.5 mil	5063±116	4198±384	5581±346
	1.0 mil	2641±163	2015±179	2210±184
25	1.5 mil	1312±103	1188±54	1707±128
	2.0 mil	1455±78	1086±126	2498±373

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A w/0.5 % Siloxane (II)

	0.5 mil	3018±154	3315±246	3704±497
	1.0 mil	1925±291	2598±159	2268±127
	1.5 mil	1144±119	1357±673	1478±53
5	2.0 mil	1358±83	1204±137	1105±90

* MVTR = Moisture Vapor Transmission Rate

A w/0.5% Lithium Bromide

	0.5 mil	4517±90	4622±979	4478±447
	1.0 mil	2838±295	2436±295	2883±234
10	1.5 mil	1765±88	2040±224	3073±647
	2.0 mil	1052±71	1459±114	1410±60

A w/0.5% Siloxane (I) and 0.5% Lithium Bromide

	0.5 mil	5703±560
	1.0 mil	4034±608
15	1.5 mil	1642±160
	2.0 mil	

This data was reduced further as shown on Table 2, by computing the mean and standard deviation of the MVTR and thickness measurements determined on three separate days

20 (N=15).

Table 2. MVTR OF UNSUPPORTED CAST FILM

Mean Sample/Thickness (measured)	MVTR (g/m ² /24 hr) (N=15)
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Polyurethaneurea (A)

25	0.6 mil	3454 ± 449
	0.97 mil	2185 ± 227
	1.5 mil	1405 ± 118
	2.0 mil	1236 ± 108

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A w/0.5% Siloxane (I)

	0.5 mil	4947 ± 699
	0.93 mil	2289 ± 320
	1.43 mil	1402 ± 271
5	2.0 mil	1271 ± 261

A w/0.5% Siloxane (II)

	0.5 mil	3346 ± 344
	0.97 mil	2261 ± 332
	1.5 mil	1326 ± 169
10	2.0 mil	1222 ± 128

A w/0.5% Lithium Bromide

	0.5 mil	4539 ± 74
	0.93 mil	2719 ± 246
	1.35 mil	1903 ± 194
15	2.0 mil	1305 ± 220

A w/0.5% Siloxane (I) and 0.5% Lithium Bromide (N=5)

	0.5 mil	5703 ± 560
	1.0 mil	4034 ± 608
	1.5 mil	1642 ± 160
20	2.0 mil	

The data was represented graphically by plotting MVTR as a function of film thickness, FIG. 1. Regression analysis yielded a power curve with the best fit. An alternate method of analyzing the data is to plot MVTR as a function of reciprocal film thickness resulting in a linear relationship between the two variables (FIGS. 2 - 6). The slope of the linear regression line with the best fit is the permeability coefficient, an important quantity for predicting the theoretical value of the MVTR at a given thickness. Analytically, the slope of a line can be calculated by dividing the y-displacement by the x-displacement or in this case by dividing the MVTR by the reciprocal film thickness. As this number becomes increasingly large, it means that a small reduction in

- 20 -

the film thickness will result in a greater increase in the MVTR. Table 3 contains the slope of the linear regression line and the MVTR value of a 0.5 mil film calculated from the slope and the y-intercept of the
5 regression analysis.

Table 3. SLOPE OF LINEAR REGRESSION LINE AND
CALCULATED MVTR OF 0.5 MIL FILM

	Sample	Slope <u>g mil/m²/24 hr</u>	MVTR <u>(g/m²/24 hr)</u>
10	A	1948	4081
	A w/0.5% Siloxane (I)	2575	4866
	A w/0.5% Siloxane (II)	1450	3416
	A w/0.5% LiBr	2185	4598
15	A w/0.5% Siloxane (I) and 0.5% LiBr	2731	5914

It is evident from Table 3 that as the value of the slope increases, the interpolated MVTR value at a 0.5 mil film thickness also increases. The textile coatings and wound dressing films require a large moisture vapor transmission rate for optimum comfort during use. The results
20 indicate the following:

Copolymer I increased the 0.5 mil MVTR of the base material by 20%. The combination of I and lithium bromide added to the polyurethaneurea A resulted in an
25 enhancement of the MVTR by 45% when compared to the unmodified A, whereas polyurethane A alone enhanced MVTR by 19% and LiBr alone enhanced MVTR by 13% compared to unmodified polymer. Thus, there appears to be synergy

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between the Copolymer I and the lithium bromide in enhancing MVTR. Copolymer II which contained no hydrophilic polyethylene oxide block actually reduced MVTR when added to A illustrating the necessary hydrophilic/hydrophobic structure of the additive for MVTR enhancement. Permeability through nonporous films is the product of the diffusivity of the permeant and its solubility in the film material. Permeability will be increased if either diffusivity or solubility is increased as long as the second quantity is not reduced in the process.

The ability of the additives according to the present invention are believed to enhance the moisture permeability (i.e., MVTR) is due to the fact that they increase both solubility and diffusivity of water in the polymer to which they are added. The silicone component in the copolymers of Example 1 (additives I and II) is responsible for enhancing diffusivity. Silicone with its low glass transition temperature, ~-130°C, and unusually flexible backbone chain has the highest diffusivity to gases and vapors of any common polymer. On the other hand, it is hydrophobic or water repelling and can actually reduce water solubility of blends with itself and the base polymer by an amount which more than compensates for the gain in diffusivity. Thus, when polymer additive II is added to the polyurethanurea, the net effect is a decrease in MVTR. Polymer additive I contains both silicone (hydrophobic) and polyethylene oxide (hydrophilic) blocks. Polyethylene oxide homopolymer is extremely water soluble. Its presence in the base polymer appears to enhance water solubility more than the silicone.

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Example 2

PREPARATION OF HIGH MOISTURE VAPOR TRANSMISSION
RATE FILMS USING POLYESTERURETHANE, POLYETHERURETHANE
AND SEGMENTED POLYURETHANEUREA AS BASE POLYMERS

5 A .5 mil thick film of Estane 5707 (B.F. Goodrich), a polyester urethane, was prepared by casting on the web coater using Mylar as the substrate. The moisture vapor transmission rate of this film was 1482 g/m² for 24 hours with the standard deviation of 118. The same film
10 containing 0.5% silicone in the form of a copolymer containing MDI and butanediol as hard segment and polydimethylsiloxane and polytetramethyleneoxide as the soft segment (II) gave a moisture vapor transmission rate of 2173 ± 157 g/m². This is a 46.6% increase in moisture
15 vapor transmission rate by adding about 1 to 1-1/2% of the terpolymer, which corresponds to about 1/2% addition of silicone.

It can be assumed from the MVTR Measurement on pure silica-free silicone that MVTR is 25,128 g/m² for 24
20 hours with the silicone component. This can be used to calculate the weighted average between the Estane 5707 and the silicone blend. From this calculation it would be expected that the MVTR would be only 1600 g/m² for 24 hours. The difference between 1600 and 2173 is 38.6%
25 unexpected increase in MVTR caused by the addition of the silicone in the form of a block copolymer.

The result of the hydrophobic/hydrophilic, or so-called amphiphilic or amphipathic, structure of additive II is apparently that both terms of the permeability are
30 increased simultaneously. That is when additions of type II are combined with a base polymer they increase the diffusivity of water through that base polymer and the solubility of water in that base polymer. Consequently, the product of these two quantities, the permeability, is
35 also increased significantly.

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- In the second example, Estane 5714 is used which is a polyetherurethane based on PTMO, butanediol and MDI. For a 0.5 mil film of the pure material, an MVTR of $3097 \pm 214 \text{ g/m}^2$ for 24 hours was obtained. The same Estane 5714 5 cast in a 0.5 mil thickness but this time containing 0.5% silicone in the form of silicone/PEOMDI/butanediol terpolymer (I) gave an MVTR of $4895 \pm 475 \text{ g/m}^2$ for 24 hours. That was an overall increase of 59% relative to the unmodified Estane 5714. Again using the weighted 10 average approach, it would be expected that MVTR for the blend would be only 3289 g/m^2 for 24 hours. Therefore, a $1606 \text{ g/m}^2/24$ hour increase in MVTR was obtained or an unexpected 48.8% increase relative to what would be expected from the weighted average.
- 15 In a third example Biomeric®, a segmented polyurethaneurea, was used. A 0.5 mil thick sheet of this material gave MVTR Of $3170 \pm 243 \text{ g/m}^2$ whereas the same material with .5% silicone in the form of the terpolymer (I) used in the above two examples gave $3963 \pm 160 \text{ g/m}^2$ for 24 hours 20 with an MVTR of 25% increase over the unmodified Biomeric. The weighted average or expected value would be 3295 g/m^2 for 24 hours. This represents a 20.3% unexpected increase in MVTR as caused by the additive.

Example 3

25 PREPARATION OF HIGH MOISTURE VAPOR TRANSMISSION
FILMS UTILIZING POLYETHER POLYESTER
ELASTOMER AS BASE POLYMER

Methylene chloride may be used to dissolve 40D Hytrel material (DuPont) but, because of its marginal solubility, cannot be prepared in a solid content above about 30 11%. The resulting dilute solution, which is stable at ~10% solids, has a viscosity which is too low to be handled easily in film preparation. By combining Cab-O-Sil fumed silica with the methylene chloride solution,

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proper viscosity may be achieved. Because the solvent based Hytrel solution is relatively nonpolar, the "Cab-O-Sil" material is not an optimally effective thickener. Low molecular weight polyethylene glycols are innocuous, 5 nontoxic materials which are polar and water soluble. Their addition to the above described solution serves to enhance the thickening action of the "Cab-O-Sil". Because they are water soluble, they can be removed in an aqueous environment rendering the film more porous than 10 it would have been in the absence of such an additive.

The same burn wound dressing material with silicone-containing block copolymer additives according to Example 1 (i.e. additive I) was prepared with polyethyleneglycol and may be useful in burn wound applications where 15 adhesion to the wound has to be minimized. Also, the film is characterized by a smooth and slippery feel which is desirable in dressing applications.

Example 4

20 PREPARATION OF HIGH VAPOR TRANSMISSION FILMS CONTAINING SILOXANE WITHOUT A BASE POLYMER

A reactor is charged under nitrogen with 35 g (0.0244 moles) polyethylene oxide, 100 g (0.0492 moles) polytetramethylene oxide, 1.5 g (0.0006 moles) polydimethylsiloxane/polyethylene oxide block copolymer, 320 ml. dimethylformamide and is heated to 45°C. Then 26.0 g (0.1040 moles) para, para'-diphenyl-methane diisocyanate 25 is added and the mixture is maintained at 45 ± 3°C with agitation for 3 hrs. Heating is halted and the reactor is charged with 0.66 ml. (0.009 moles) ethylene diamine followed immediately by 355 ml. dimethylformamide, taking caution to control the exotherm below 50°C. At approximately 30 10 minute intervals, the remainder of the ethylene 35 diamine is added according to the following schedule:

- 25 -

1st addition (described above):	0.66 ml.
2nd addition:	0.66 ml.
3rd addition:	0.33 ml.
4th addition:	<u>0.33 ml.</u>
5. Total	1.98 ml. (0.0297 moles)

The reaction mixture is stirred for approximately one hour after the final addition. A film-forming, thermoplastic material is yielded with the following properties: MVTR = $15,283 \text{ g/m}^2/24 \text{ hr.}$ for a 0.5 mil film. Young's modulus = $610 \pm 38 \text{ PSI}$, tensile strength = 4514 PSI, ultimate elongation = 1085.

Example 5

15 PREPARATION OF HIGH VAPOR
TRANSMISSION FILMS CONTAINING SILOXANE
WITHOUT A BASE POLYMER

A reactor is charged under nitrogen with 58.0 g (0.0405 moles) polyethylene oxide, 71.0 g (0.0349 moles) polytetramethylene oxide, 1.7 g (0.0007 moles) of a polydimethylsiloxane/polyethylene oxide block copolymer, and 250 ml. dimethylformamide, heated to $45 \pm 3^\circ\text{C}$. Add 31.8 g (0.1272 moles), para, para'-diphenylmethane diisocyanate and maintained at 45°C with agitation for 3 hrs. Then 350 ml. dimethylformamide is added, followed by a solution of 3.42 ml. ethylene diamine dissolved in 100 ml. dimethylformamide gradually added over approximately a one-half hr. period. The reaction temperature is maintained to less than 50°C throughout the addition of chain extender. Following chain extension, the solution is stirred for an additional hour. This yields a film-forming material with the following properties: MVTR = $36,243 \text{ g/m}^2/24 \text{ hr.}$ for 0.5 mil film. Young's modulus = $1194 \pm 95 \text{ PSI}$, tensile strength = $3156 \pm 176 \text{ PSI}$, ultimate elongation (%) = 1046 ± 59 . Young's modulus of a

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wet film (24 hrs. water immersion) = 858 ± 50 PSI,
tensile strength of a wet film = 2484 ± 97 PSI, ultimate
elongation (%) = 1204 ± 63.

Example 6

5

**PREPARATION OF HIGH VAPOR TRANSMISSION
FILMS WITHOUT SILOXANE AND WITHOUT
A BASE POLYMER**

A nitrogen-purged reactor is charged with 57.9 g (0.0404 moles) polyethylene oxide, 72.8 g (0.0358 moles) poly-
10 tetramethylene oxide, and 250 ml dimethylformamide and the temperature is raised to 45 + 3°C. Then 31.8 g (0.1272 moles) para, para'-diphenylmethane diisocyanate is added and the mixture is agitated for 3 hours at 45°C.

Then 350 ml additional dimethylformamide is added followed by gradual addition of a solution of 3.07 g (0.0510 moles) ethylene diamine in 100 ml dimethylformamide over a one-half hour period. The solution temperature is maintained to less than 50°C throughout the reaction of the chain extender.

20 Following complete addition of the chain extender, the mixture is agitated for an additional hour. This yields a film-forming material with the following properties:

MVTR = 21,738 g/m²-24 hours for a 0.5 mil film
Young's Modulus = 998 ± 67 psi
25 Tensile Strength = .3414 ± 228 psi
Ultimate Elongation (5) = 937 ± 30
Young's Modulus of a wet film (24 hours water immersion) = 854 ± 60 psi
Tensile Strength of a wet film = 3232 ± 105 psi
30 Ultimate Elongation (%) of a wet film = 1156 ± 89

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Example 7

PREPARATION OF HIGH VAPOR TRANSMISSION
FILMS CONTAINING SILOXANE WITHOUT
A BASE POLYMER

5 A reactor under nitrogen atmosphere is charged with 39.7 g (0.0277 moles) polyethylene oxide, 38.2 g (0.0188 moles) polytetramethylene oxide, 1.6 g (0.0007 moles) of a polydimethylsiloxane/polyethylene oxide block copolymer, and 61.5 g (0.2458 moles) para, para'-diphenylmethane diisocyanate, and 200 ml dimethylformamide, then 10 heated to 42 ± 3°C. The temperature is maintained with agitation for 3 hours, then diluted with 60 additional ml dimethylformamide.

Then 17.9 g (0.1987 moles) 1,4-butanediol in 75 ml 15 dimethylformamide is placed into an additional funnel and approximately 3/4 of this butanediol solution is added to the reaction mixture. After one hour, the remainder of the solution is added and the mixture is allowed to react for 2 additional hours. A film-forming material was 20 yielded possessing the following characteristics:

MVTR = 7618 g/m²-24 hours for a 0.5 mil film thickness

Young's Modulus = 3915 ± 257 psi

Tensile Strength = 4388 psi

Ultimate Elongation (%) = 729 ± 31

Young's Modulus of a wet film (24 hours water 25 immersion) = 3767 ± 128 psi

Tensile Strength of a wet film = 3592 ± 151 psi

Ultimate Elongation (%) of a wet film = 756 ± 37

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What is Claimed is:

1. A moisture vapor permeable material comprising a base polymer and a segmented block multipolymer additive; said additive comprising, an essentially linear 5 segmented copolymer chain characterized by at least one hard segment and at least one copolymer soft block comprising hydrophobic and hydrophilic components.
2. A material according to Claim 1 wherein said base polymer is selected from the group consisting of 10 polyurethanes, polysulfones, polyesters, polyethylenes, polypropylenes, polystyrene, poly-(acrylonitrilebutadiene-styrene), polybutadiene, polyisoprene, styrene-butadiene-styrene, styrene-isoprene-styrene, poly-(4-methyl-pentene), polyisobutylene, polymethylmethacrylate, 15 polyvinylacetate, polyacrylonitrile, polyvinylchloride, polyethylene terephthalate, cellulose and cellulose esters.
3. A material according to Claim 2 wherein said base polymer is a polyurethane selected from polyurethane, 20 polyether urethaneurea, polyetherurethane or polyesterurethane.
4. A material according to Claim 3 wherein said base polymer comprises a polyurethaneurea formed from polymerization of diphenylmethane diisocyanate, ethylene 25 diamine and polytetramethylene.
5. A material according to Claim 3 wherein said hard segment is a homopolymer selected from the group consisting of polyurethane, polyether urethane urea, 30 polyetherurethane and polyesterurethane.
6. A material according to Claim 5 wherein said hydrophobic component of said soft block is a

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polydialkylsiloxane; polytetraalkylene oxide, polyfluoro-alkyl alkylsiloxane, polyolefin, polydiene or polyfluorocarbon.

7. A material according to Claim 6 wherein said
5 hydrophilic component of said soft block is a polyalkylene oxide or polyvinylalkanoate.

8. A material according to Claim 7 wherein said hydrophobic component comprises polydialkylsiloxane and said hydrophilic component comprises polyalkylene oxide.

10 9. A material according to Claim 1 in the form of a film.

10. A material according to Claim 9 wherein said film is of a uniform thickness less than 5.0 mil.

11. A wound dressing comprising a base polymer and
15 a segmented block multipolymer additive; said additive comprising an essentially linear segmented copolymer chain characterized by at least one hard segment and at least one copolymer soft block comprising hydrophobic and hydrophilic components; said base polymer selected from
20 the group consisting of polyurethanes, polysulfones, polyesters, polyethylenes, polypropylenes, polystyrene, poly-(acrylonitrilebutadiene-styrene), polybutadiene, polyisoprene, styrene-butadiene-styrene, styreneiso-
25 prene-styrene, poly-(4-methyl-pentene), polyisobutylene, polymethylmethacrylate, polyvinylacetate, polyacrylonitrile, polyvinylchloride, polyethylene terephthalate, cellulose and cellulose esters.

12. A dressing according to Claim 11 wherein said base polymer is a polyurethane selected from polyurethane, polyether urethaneurea, polyetherurethane or polyesterurethane.

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13. A dressing according to Claim 12 wherein said base polymer comprises a polyurethaneurea formed from polymerization of diphenylmethane diisocyanate, ethylene diamine and polytetramethylene.

5 14. A dressing according to Claim 12 wherein said hard segment is a homopolymer selected from the group consisting of polyurethane, polyether urethane urea, polyetherurethane and polyesterurethane.

10 15. A dressing according to Claim 14 wherein said hydrophobic component of said soft block is a polydialkylsiloxane; polytetraalkylene oxide polyfluoroalkyl alkylsiloxane, polyolefin, polydiene or polyfluorocarbon.

15 16. A dressing according to Claim 15 wherein said hydrophilic component of said soft block is a polyalkylene oxide or polyvinylalkanoate.

17. A dressing according to Claim 16 wherein said hydrophobic component comprises polydialkylsiloxane and said hydrophilic component comprises polyalkylene oxide.

20 18. A coated textile comprising a fabric web and a uniform coating on at least one surface of said web, said coating comprising a base polymer and a segmented block multipolymer additive; said additive comprising, an essentially linear segmented copolymer chain characterized by at least one hard segment and at least one 25 copolymer soft block comprising hydrophobic and hydrophilic components;

base polymer selected from the group consisting of polyurethanes, polysulfones, polyesters, polyethylenes, polypropylenes, polystyrene, poly(acrylonitrilebutadiene-styrene), polybutadiene, polyisoprene, styrene-butadiene-styrene, styreneisoprene-styrene, poly-(4-methyl-pentene), polyisobutylene, polymethylmethacrylate, polyvinylacetate, polyacrylonitrile, polyvinylchloride,

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polyethylene terephthalate, cellulose and cellulose esters.

19. A textile according to Claim 18 wherein said base polymer is a polyurethane selected from polyurethane, polyether urethaneurea, polyetherurethane or polyesterurethane.

20. A textile according to Claim 19 wherein said base polymer comprises a polyurethaneurea formed from polymerization of diphenylmethane diisocyanate, ethylene diamine and polytetramethylene.

21. A textile according to Claim 19 wherein said hard segment is a homopolymer selected from the group consisting of polyurethane, polyether urethane urea, polyetherurethane and polyesterurethane.

22. A textile according to Claim 21 wherein said hydrophobic component of said soft block is a polydialkylsiloxane; polytetraalkylene oxide, polyfluoroalkyl alkylsiloxane, polyolefin, polydiene or polyfluorocarbon.

23. A textile according to Claim 22 wherein said hydrophilic component of said soft block is a polyalkylene oxide or polyvinylalkanoate.

24. A textile according to Claim 23 wherein said hydrophobic component comprises polydialkylsiloxane and said hydrophilic component comprises polyalkylene oxide.

25. A method of forming a moisture vapor permeable article comprising the steps of:

(a) providing a mixture of a base polymer and a segmented block multipolymer additive, said additive comprising an essentially linear segmented copolymer chain characterized by at least one hard segment and at

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least one copolymer soft block comprising hydrophobic and hydrophobic components;

(b) forming the mixture from step (a) into said article.

5 26. The method according to Claim 25 wherein said step (b) comprising forming said mixture into a film.

27. The method according to Claim 25 wherein said step (b) comprises coating said mixture onto a fabric web.

10 28. A method according to Claim 25, 26 or 27 wherein said base polymer is selected from the group consisting of polyurethanes, polysulfones, polyesters, polyethylenes, polypropylenes, polystyrene, poly(acrylonitrilebutadiene-styrene), polybutadiene, polyisoprene, 15 styrene-butadiene-styrene, styrene-isoprene-styrene, poly-(4-methyl-pentene), polyisobutylene, polymethyl-methacrylate, polyvinylacetate, polyacrylonitrile, polyvinylchloride, polyethylene terephthalate, cellulose and cellulose esters.

20 29. A method according to Claim 28 wherein said base polymer is a polyurethane selected from polyurethane, polyether urethaneurea, polyetherurethane or polyesterurethane.

25 30. A method according to Claim 29 wherein said base polymer comprises a polyurethaneurea formed from polymerization of diphenylmethane diisocyanate, ethylene diamine and polytetramethylene.

30 31. A method according to Claim 29 wherein said hard segment is a homopolymer selected from the group consisting of polyurethane, polyether urethane urea, polyetherurethane and polyesterurethane.

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32. A method according to Claim 31 wherein said hydrophobic component of said soft block is a polydi-alkylsiloxane; polytetraalkylene oxide, polyfluoroalkyl alkylsiloxane, polyolefin, polydiene or polyfluorocarbon.

5 33. A method according to Claim 32 wherein said hydrophilic component of said soft block is a polyalkylene oxide or polyvinylalkanoate.

10 34. A method according to Claim 33 wherein said hydrophobic component comprises polydialkylsiloxane and said hydrophilic component comprises polyalkylene oxide.

15 35. A moisture vapor permeable segmented block multipolymer comprising an essentially linear segmented copolymer chain characterized by at least one hard segment and at least one copolymer soft block comprising hydrophilic and hydrophobic components.

20 36. A multipolymer according to Claim 35 wherein said hard segment is a homopolymer selected from the group consisting of condensation products of diphenylmethane diisocyanate with a diamine and diphenylmethane diisocyanate with a diol.

37. A multipolymer according to Claim 36 wherein said hydrophilic component comprises polyethylene oxide and said hydrophobic component comprises polytetramethylene oxide.

25 38. A multipolymer according to Claim 37 wherein said soft block further comprises a polydialkylsiloxane hydrophobic component.

39. A multipolymer according to Claim 37 comprising:

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15-50% (by weight) of said hard segment
20-45% polyethylene oxide
(1000-3000 mol. wt. (number avg.))
25-65% polytetramethylene oxide
5 100%

40. A multipolymer according to Claim 39 further comprising up to 2% by weight polydimethylsiloxane.

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MATERIAL A OF EXAMPLE I

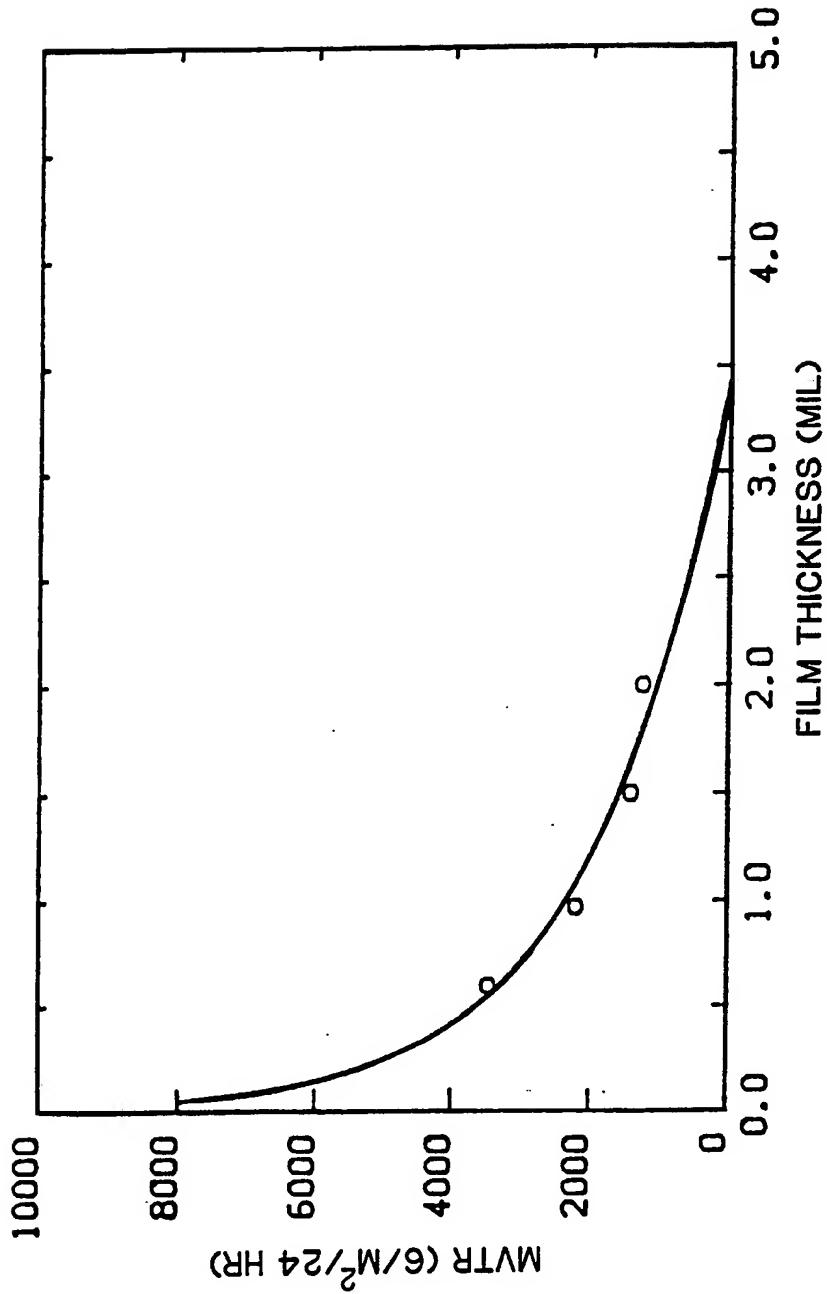


FIGURE I

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MATERIAL A OF EXAMPLE I

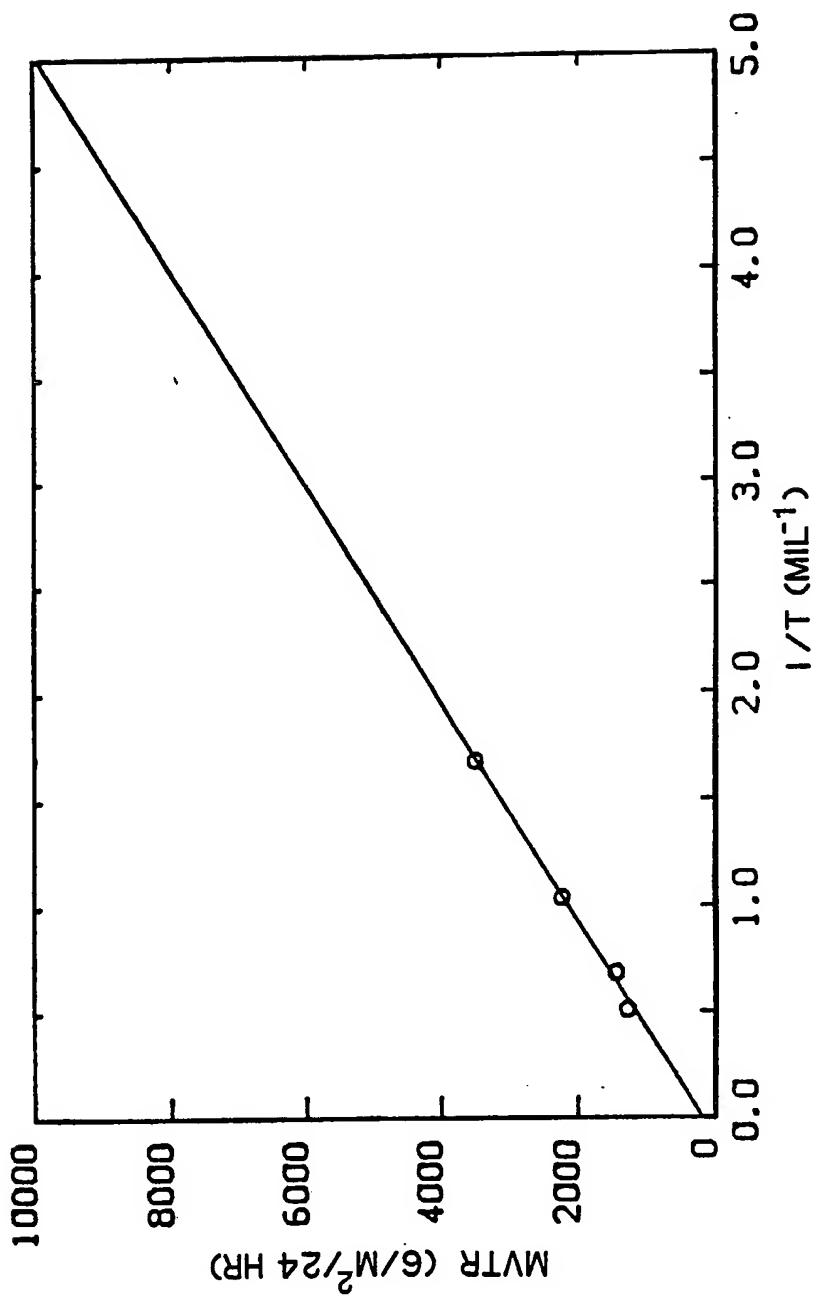


FIGURE 2

3/6

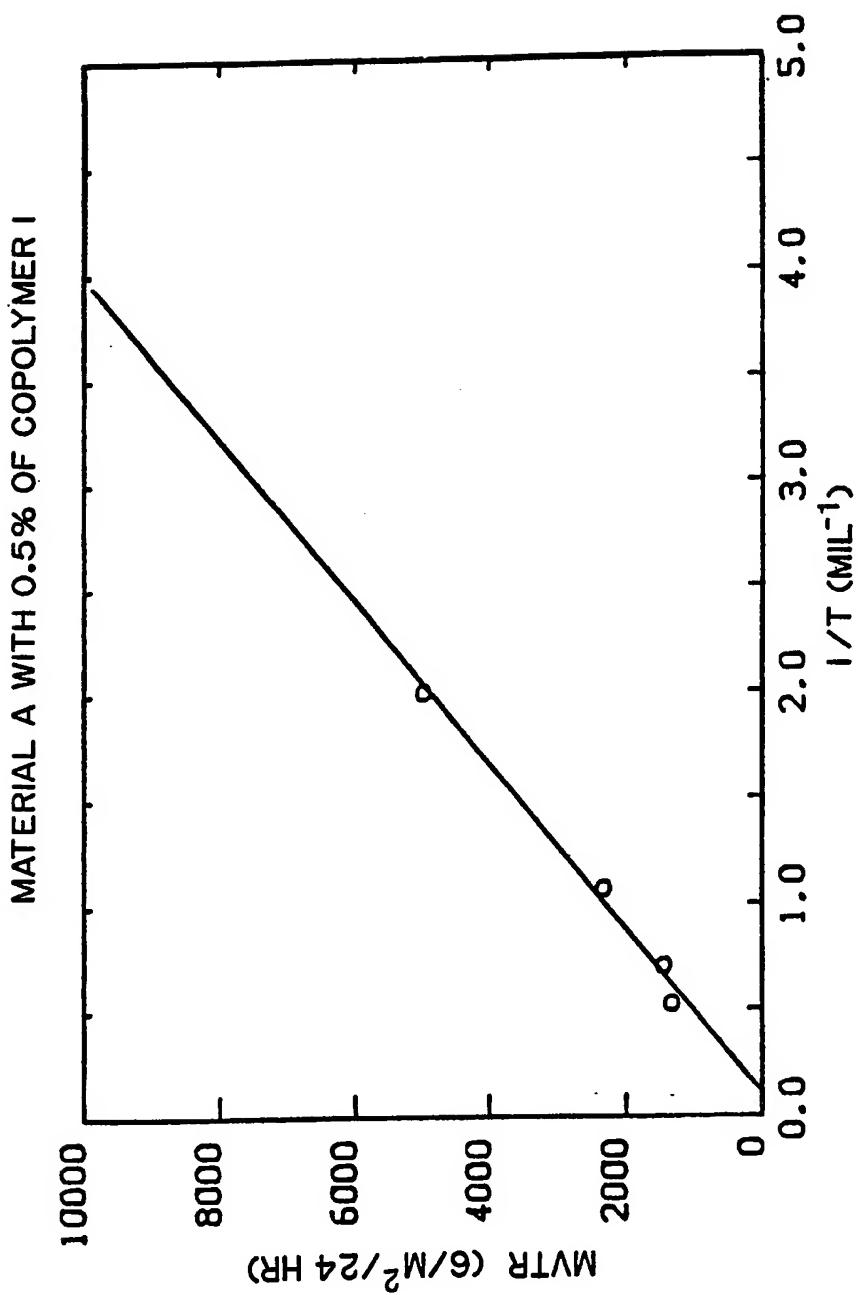


FIGURE 3

4/6

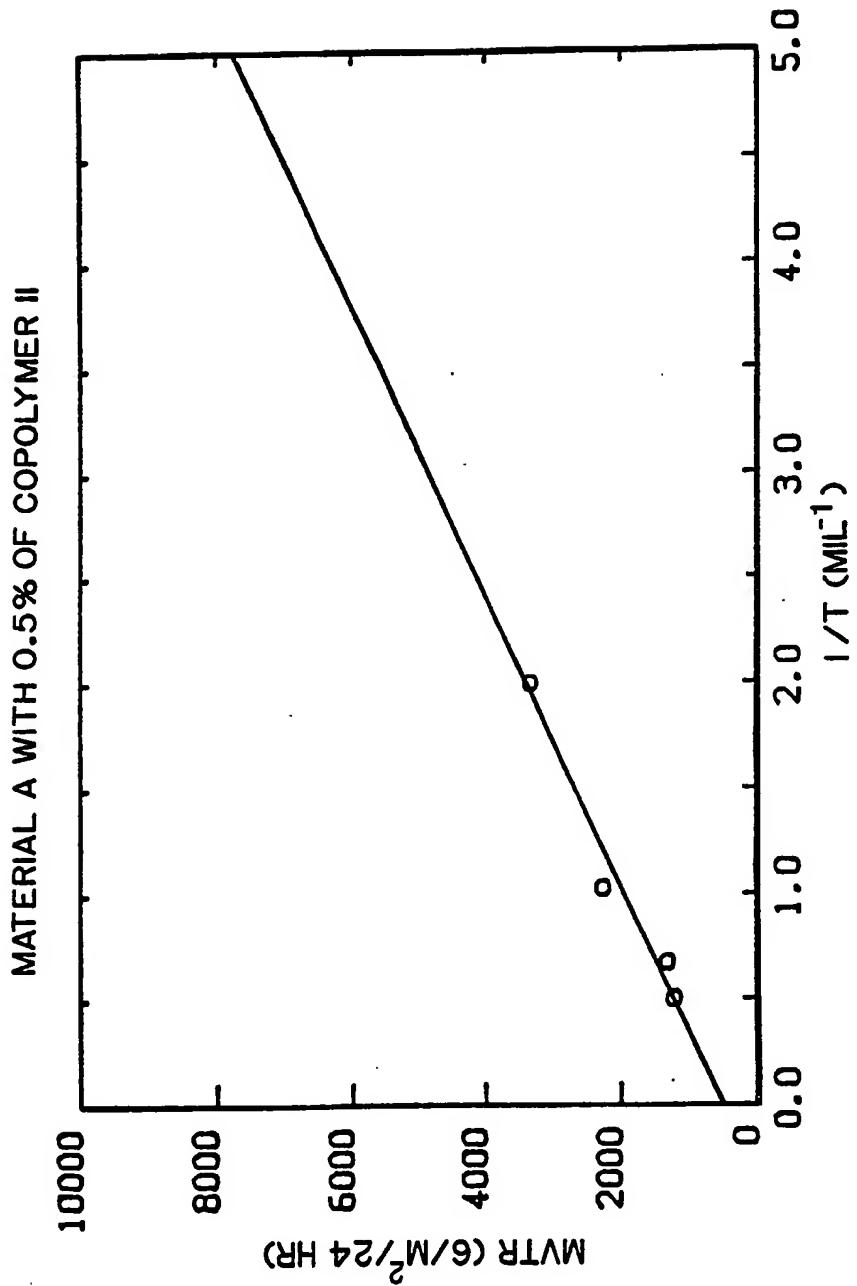


FIGURE 4

SUBSTITUTE SHEET

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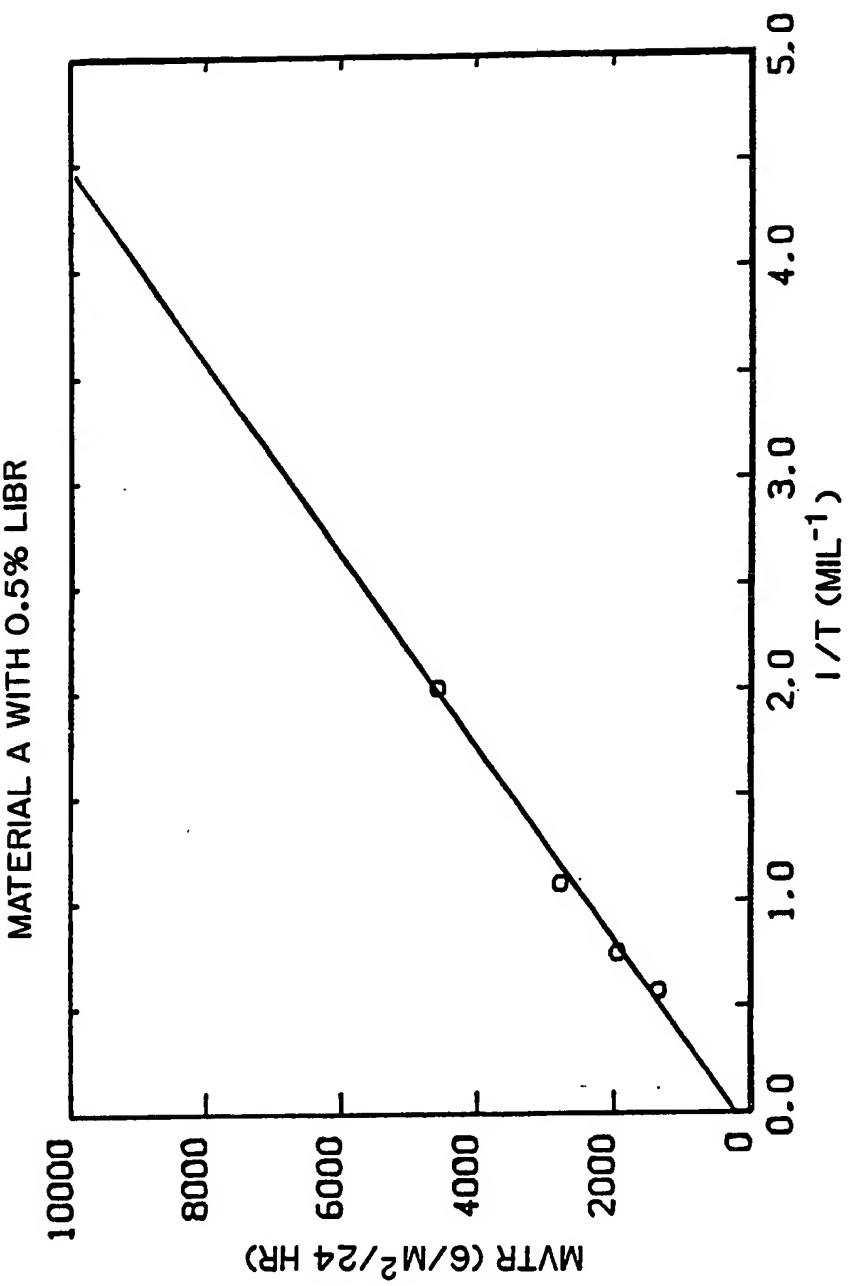


FIGURE 5

SUBSTITUTE SHEET

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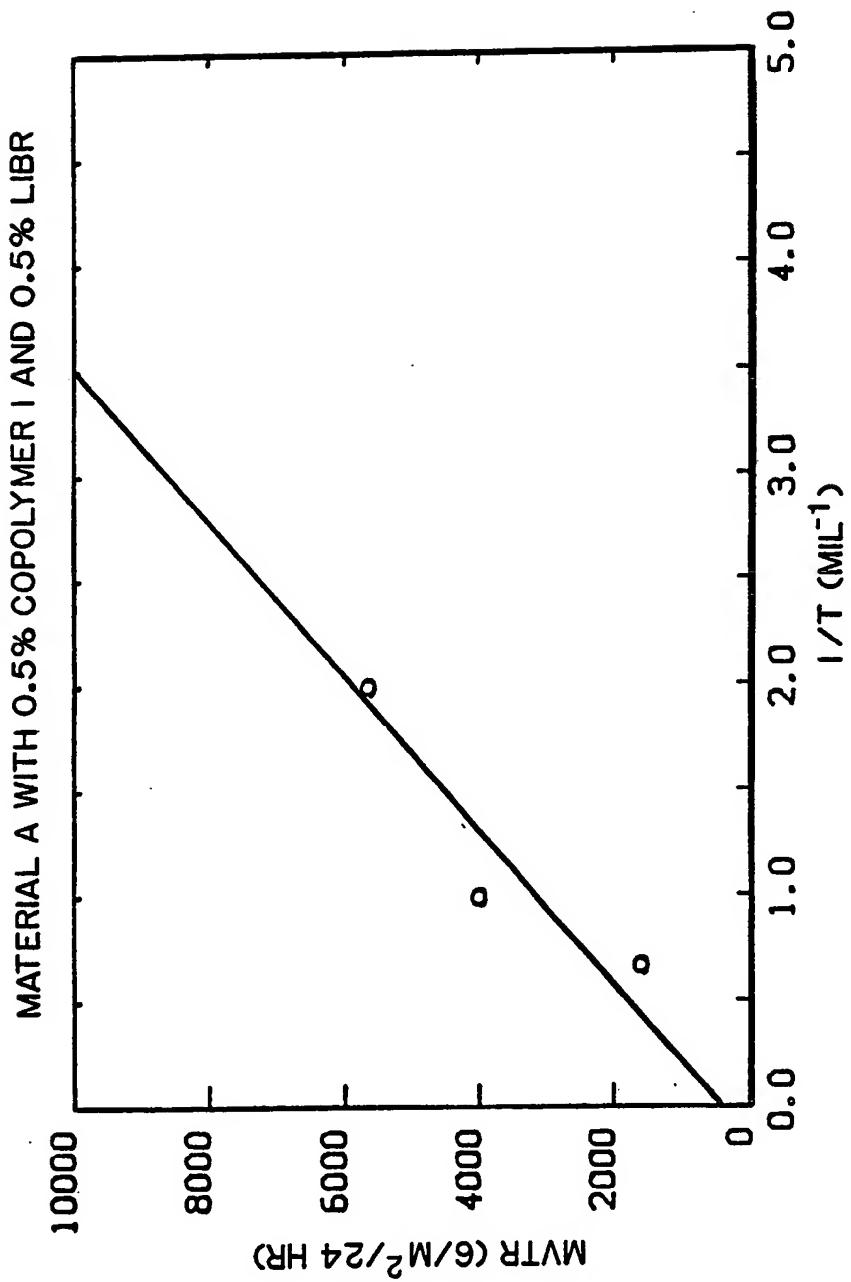


FIGURE 6

INTERNATIONAL SEARCH REPORT

International Application No PCT/US85/00946

I. CLASSIFICATION OF SUBJECT MATTER (If several classification symbols apply, indicate all) ³

According to International Patent Classification (IPC) or to both National Classification and IPC
 INT. CL. 3 C08L 75/04; B32B 27/40, 27/06
 U.S. CL. 525/90, 453, 458; 428/423.1, 480, 532

II. FIELDS SEARCHED

Minimum Documentation Searched ⁴

Classification System	Classification Symbols
U.S.	525/90, 453, 458; 428/423.1, 480, 532

Documentation Searched other than Minimum Documentation
to the Extent that such Documents are Included in the Fields Searched ⁵

III. DOCUMENTS CONSIDERED TO BE RELEVANT ¹⁴

Category ⁶	Citation of Document, ¹⁵ with indication, where appropriate, of the relevant passages ¹⁷	Relevant to Claim No. ¹⁸
X	US, A, 3,666,542 30 MAY 1972 KIGANE ET AL	1-7, 9-16, 18-23, 25- 33, 35-37 & 39
Y	US, A, 3,567,499 02 MARCH 1971 KLEBERT ET AL	1-40
Y	US, A, 4,052,495 04 OCTOBER 1977 UHLMANN ET AL	1-40
Y, P	US, A, 4,464,431 07 AUGUST 1984 HISAKI ET AL	35-40
A	US, A, 3,541,053 17 NOVEMBER 1970 HARRELL, JR.	

* Special categories of cited documents: ¹⁵

- "A" document defining the general state of the art which is not considered to be of particular relevance
- "E" earlier document but published on or after the international filing date
- "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

"&" document member of the same patent family

IV. CERTIFICATION

Date of the Actual Completion of the International Search ¹⁹	Date of Mailing of this International Search Report ²⁰
10 JUNE 1985	17 JUN 1985
International Searching Authority ¹	Signature of Authorized Officer ²⁰
ISA/US	 W.J. BRIGGS, SR.